



Dart Aerospace Ltd.
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D2353

Job Sheet 196651



DAS
21
9-89

Part No: D2353

Job Qty: 12 pcs

Part Name: Stiffener



Part Weight: 0 lbs

Job Created: 6/18/19

Due Date: 7/12/19

Type: Stock

Note: DWG REV C IPP Rev: A Removed from 9 Digit 05-11-10 EC IPP: B 06.11.15 waterjet EC IPP: c 06.12.07 ecn 836 ec

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		7/12/19	0.17	0.75	Waterjet - Flow	6/17/19	JRB
120	QC 8	12 pcs		7/12/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	12 pcs		7/12/19	0.25	0.46	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		

PRIORITY

AUG 21 2019

SEP 3 2019

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				Small Fab - Brake - 3 - B4B	
140 QC 5	12 pcs	7/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Handfinish - 1-1 Chemical-B4B	12 pcs	7/12/19	0.00 0.50	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
155 QC 7	12 pcs	7/12/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	

DAS
4-D
9-89

SEP 03 2019

SEP 03 2019

					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	BL1
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
160	Powdercoat - 4 Black Sand - B4B	12 pcs	7/12/19	0.00 0.18	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BL 19-9-3
					Powdercoat - 4 - B4B	
170	QC 3	12 pcs	7/12/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	SEP 03 2019
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
180	Packaging 3-1 - Stock - B4B	12 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	

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				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	DC ST 2 LSA
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	12	7/12/19	0.00 0.00	QC 21 - SA - 21	DAB
	pcs			QC 21 - SA - 70	21 SEP 04 2019
				QC 21 - SA - 53	DAB

Part Op 100 - 1-Cut as per Dwg D2353
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg) Bend per Dwg D2353
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 155 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Black Sandtex(Ref.4.3.5.7) per QSI005 4.3) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	1.7556 sf (.1463 ea)	100-Waterjet - Flow - 1	5155296

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	2	79	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stiffener	15.198Inches ± 0.010	15.208 15.188		
2	Stiffener	0.966Inches ± 0.005	0.971 0.961		
3	Stiffener	0.354Inches ± 0.010	0.364 0.344		
4	Stiffener	0.128Inches + 0.005 - 0.000	0.133 0.128		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS																																																													
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐																																																										
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐																																																										
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐																																																										
					Quality ☐																																																										
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)																																																											
Description Work Order Deviation		Disposition																																																													
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr></table>				Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Fit/Function	☐	Off-set/Set-up	☐		
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Completed By		Lead hand / Supervisor																																																													
		QC / QA Coordinator																																																													